

Work Order ID 70855

Thursday, June 16, 2011 2:21:15 PM



Page 1

Item ID: D3463-1

Accept



Setup Start



Revision ID:

Item Name: Arm

Stop



Start Date: 6/16/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-06-16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3463

Rev B

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank 25.00 " long

11/08/03

6

105

0.00



Lathe Conv

Memo

Conventional Lathe

Ream tube at both ends aprox 2" deep at .750" Dia

11/08/03

6

110

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

1-Bend as per dwg D3463-2-Trim to length per dwg D3463-3- Debur

11/08/05

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/16/08

6

Quality Control

Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim.

130

CONVENTIONAL MILLING MACHINE

0.00



Mill Conv

Memo

0.00

11/08/08

6

Conventional Milling Machine

1- Drill as per dwg D3463(One side only)
2-Deburr as per dwg D3463

140

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

11/08/08

6

Quality Control

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Page 3

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S.uloslog

76

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

62

11/6/08

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/09

CMF 11-08-08

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 16, 2011 2:21:22 PM

Page 1

Work Order ID: 70855

Parent Item: D3463-1

Parent Item Name: Arm



Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC IPP REV:B
ADDED MANUAL LATHE STEP 10-06-02 JLM VER:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M316TR1.00W.120		Purchased	No			100	f	25.5000	2.083	13.15579			

316 RD tubing 1.00 x .120w

Location	Loc Qty	Loc Code
MAT037	25.5	
111096	5.5	
117890	20	

118390

13.2 *PA* 4/08/03

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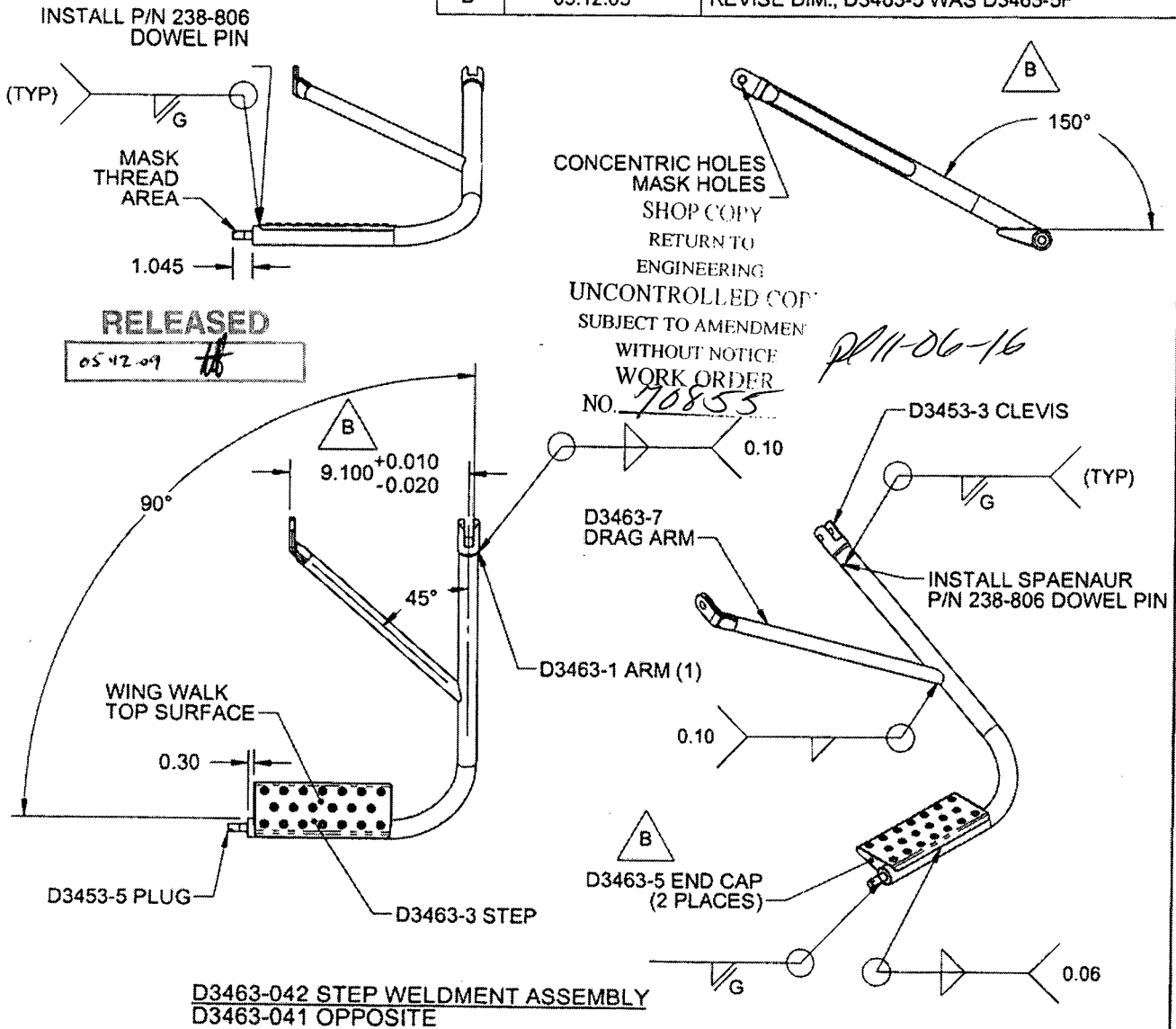
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT	SCALE 1:8	
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.: D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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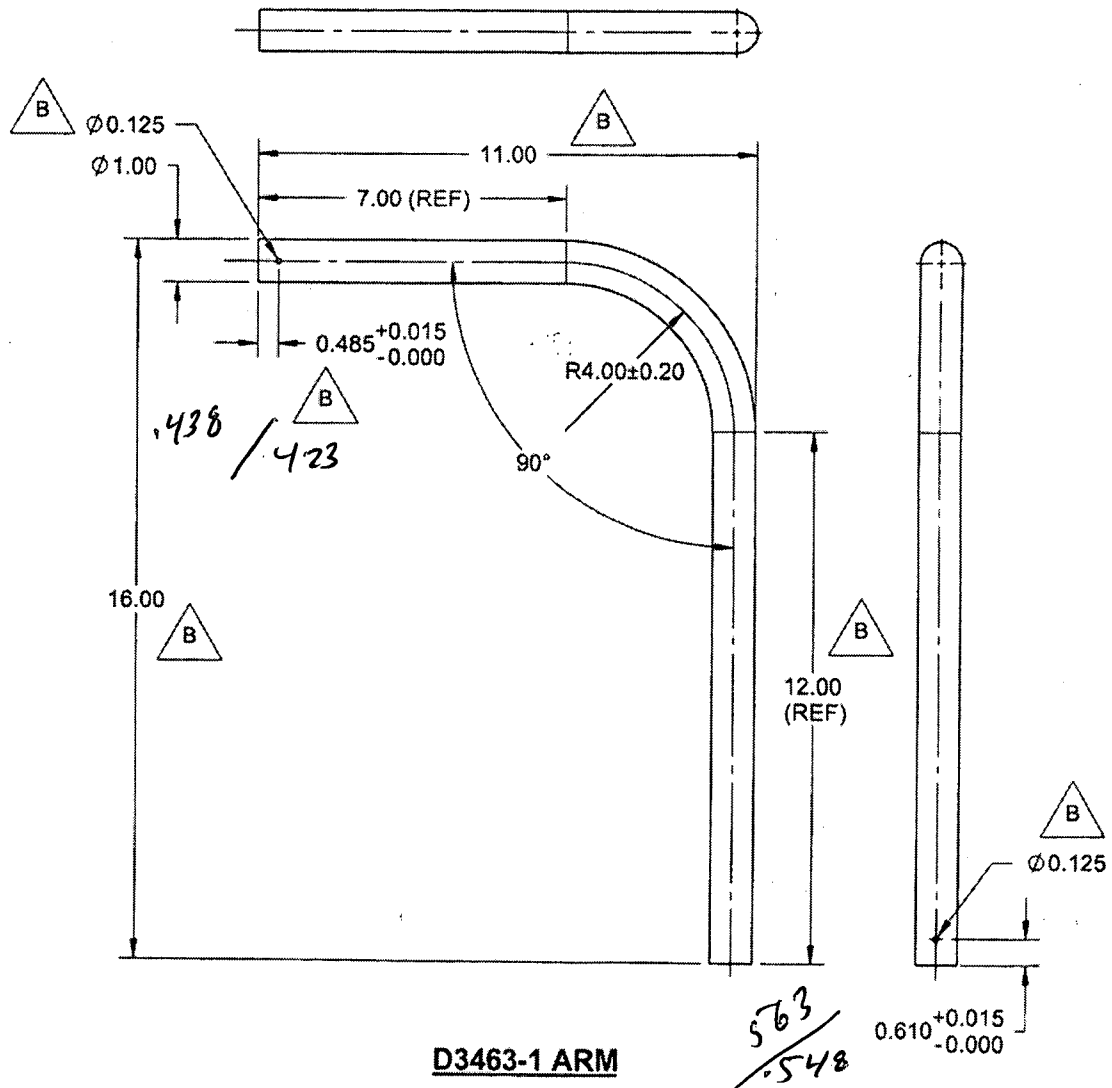
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT	SCALE 1:4	

RELEASED05.12.05 *[Signature]*

u/b 10855

**D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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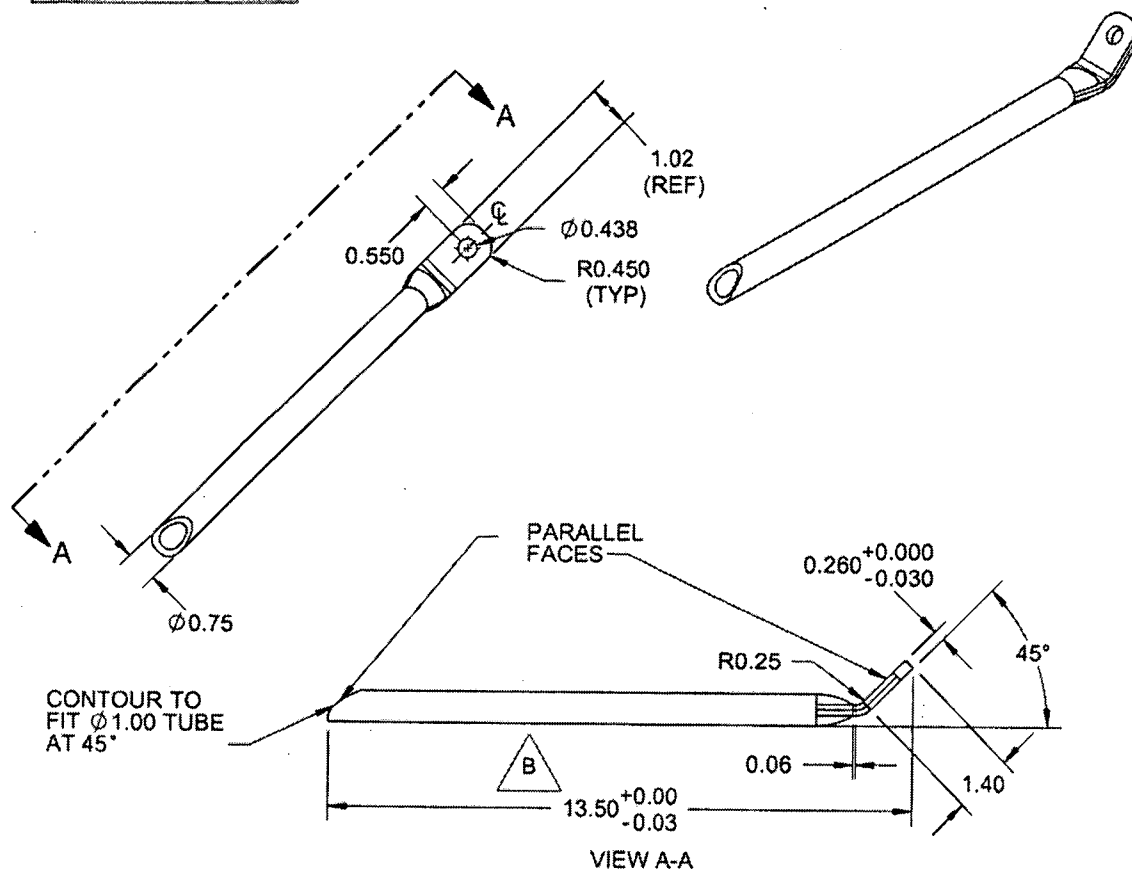
NOTE: Date & initial all entries

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT SCALE 1:4	

RELEASED

05.12.09

WFO 70855



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

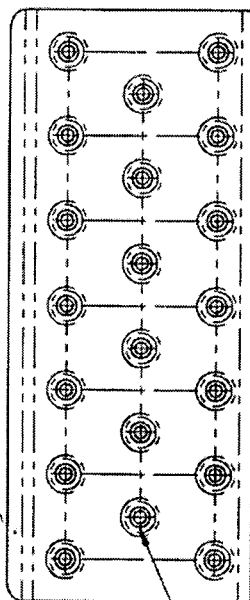
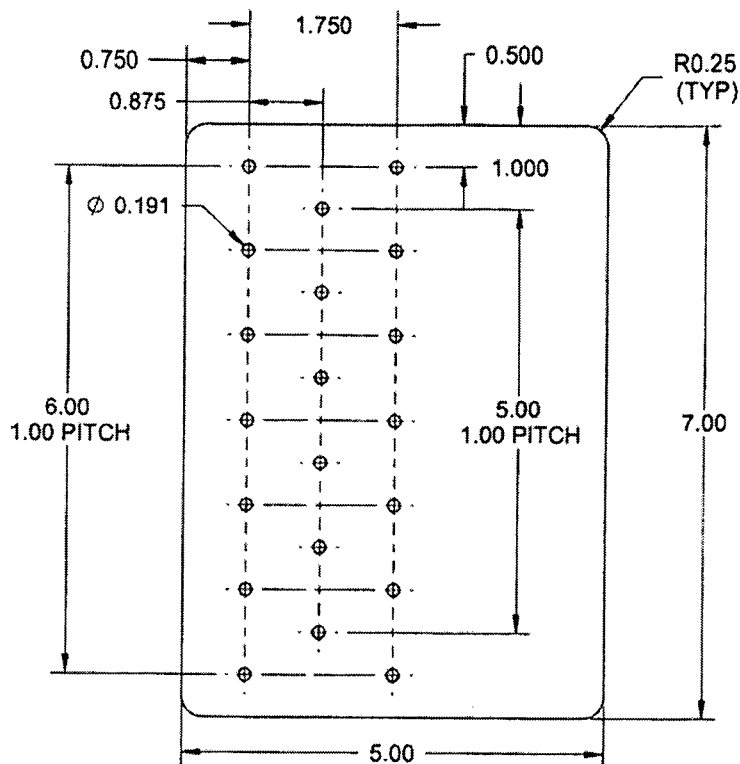
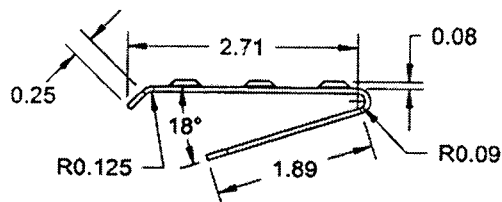
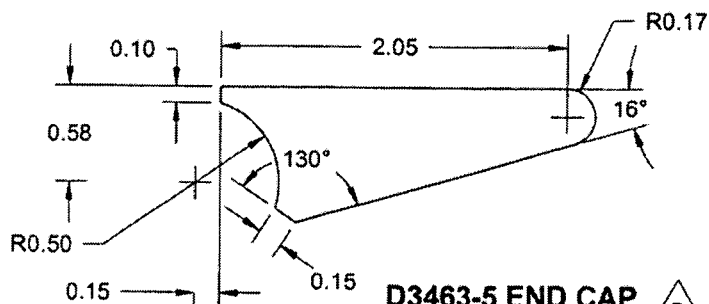
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DART

Wb 70855

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED05.12.09 *#*FORM USING
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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